

Work Order ID 50334

July 14, 2009 12:12:15 PM



Page 1

Item ID: D3163-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Plate

Start Date: 7/15/09 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09-07-15 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3163	Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3163 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-
Deburr if necessary

MF 09 08 24 (4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MF 09 08 24 (4)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

→ 801/06/24

(4) φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Qty: 4.00

Required Date: 7/15/09

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo
Debur

u/25

0.00

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

u/ 09/08/25

4

Ø

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 09-08-25

④.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3163-3

Accept

Setup Start

Revision ID: D

Stop

Item Name: Plate

Start Date: 7/15/09 Start Qty: 4.00

Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Peg/26 (9)

09/08/26 HJ

BP 09-8-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 12:12:15 PM

Work Order ID: 50334



Parent Item: D3163-3RevD



Parent Item Name: Plate

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	163.2716	1.3558			



2024-T3 .063 sheet



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	163.2715789	
102942	1.5	
105916	3.69	
106223	1.47	
109463	24.2	
110980	15.45	
111787	114.961579	
19059	2	

ml 09 08 24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

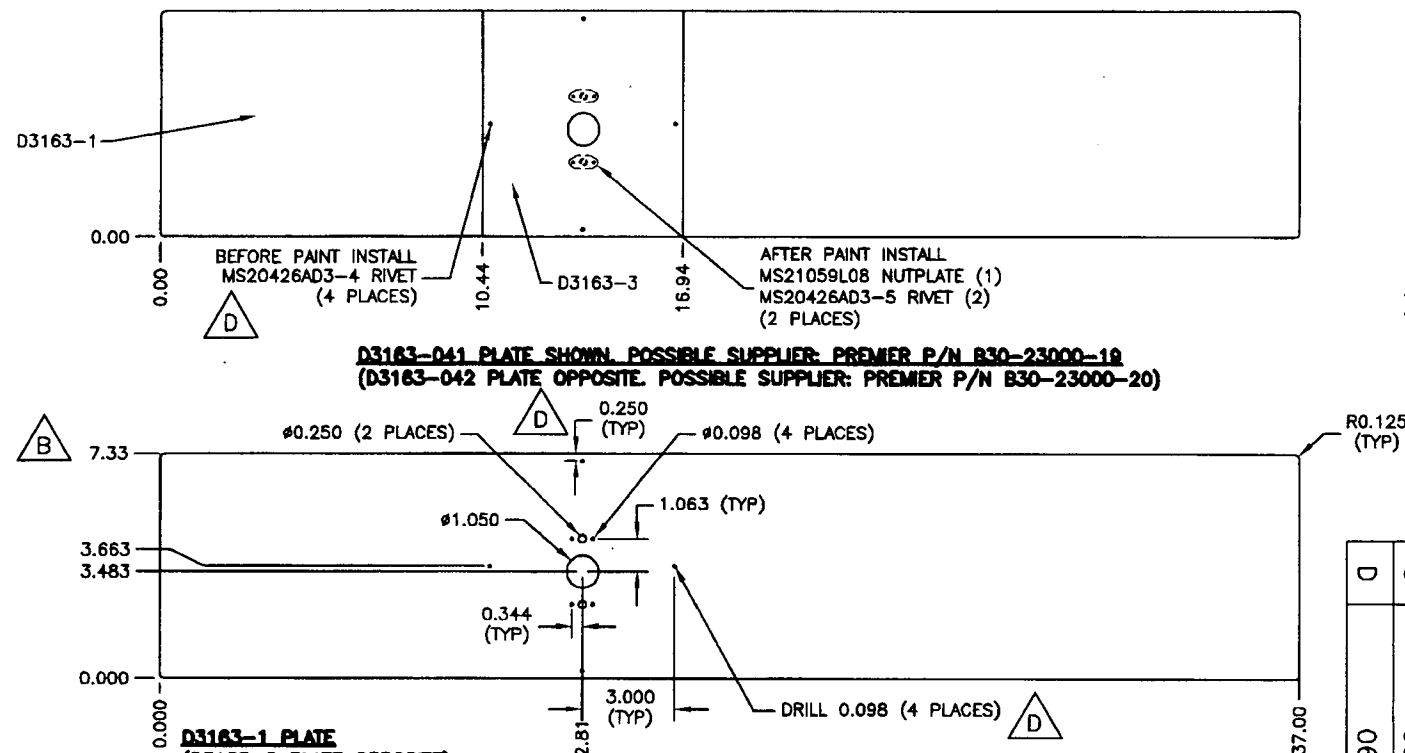
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART

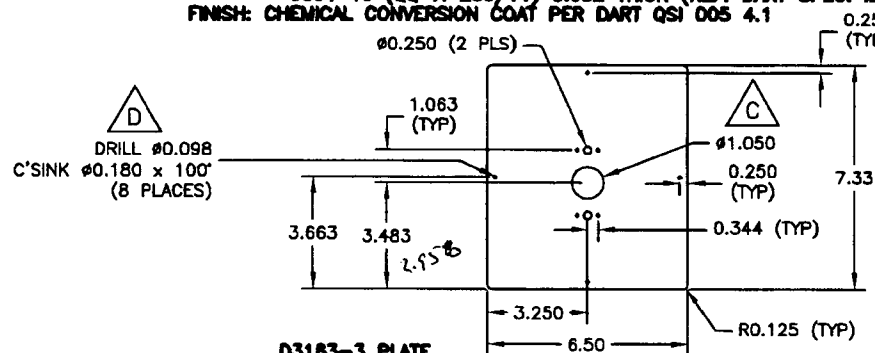
RELEASED
06-06-26

DESIGN	RF	DRAWN BY	CB	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. D
CHECKED	PH	APPROVED	PH	DRAWING NO. D3163	SHEET 1 OF 1
DATE	06.06.26	TITLE	PLATE	SCALE	1:6
A	02.04.26	NEW ISSUE			
B	04.10.06	7.33 WAS 7:20; REMOVE PERIMETER HOLES			
C	05.11.22	Ø1.050 WAS Ø1.000			
D	06.06.26	ADD 4 RIVETS; REMOVE ADHESIVE			



D3163-041 PLATE SHOWN. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19
(D3163-042 PLATE OPPOSITE. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)

D3163-1 PLATE
(D3163-2 PLATE OPPOSITE)
MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032) OR
6061-T6 (QQ-A-250/11) 0.032 THICK (REF. DART SPEC. M6061T6S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



D3163-3 PLATE
MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063) OR
6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

GENERAL NOTES:

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE BUT BEFORE INSTALLATION OF MS21059L08 NUTPLATES
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50334
mf
09-07-15